

SOON

Work Order ID 74501

Monday, October 03, 2011 10:39:16 AM

Page 1

Item ID: D2934

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle Spacer

Start Date: 9/30/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2934

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2934

11 Dwg Rev: B

11 Prog Rev: B 12-

Deburr if necessary

B11-10-4

39

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/11/10/04

LOANED
X34

Work Order ID 74501

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

34
counted & 11/10/05

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

34 x 2 M-11/10/05

150

Identify as per dwg & Stock Location. 027

0.00



Packaging

Memo

0.00

Packaging

Rec'd 10/5 (34)

Work Order ID 74501

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Monday, October 03, 2011 10:39:16 AM

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Accept



Setup Start



Revision ID:

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Item Name: Saddle Spacer

Start Date: 9/30/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/6
mf
11-10-6

Picklist Print

Monday, October 03, 2011 10:39:13 AM

Page 1

Work Order ID: 74501

Parent Item: D2934

Parent Item Name: Saddle Spacer



Start Date: 9/30/2011

Required Date: 10/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A:00.06.06: [New Issue] [EC:1]
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased			No	100	sf	348.3000	0.0318	0.669474			



6061-T6 .080 Sheet



B11-10-4

Location

Loc Qty

Loc Code

MAT021

348.3

117285

19.3

119009

171

119028

158

119029


32

DART AEROSPACE LTD	Work Order:	74501
Description: Saddle Spacer	Part Number:	D2934
Inspection Dwg: D2934 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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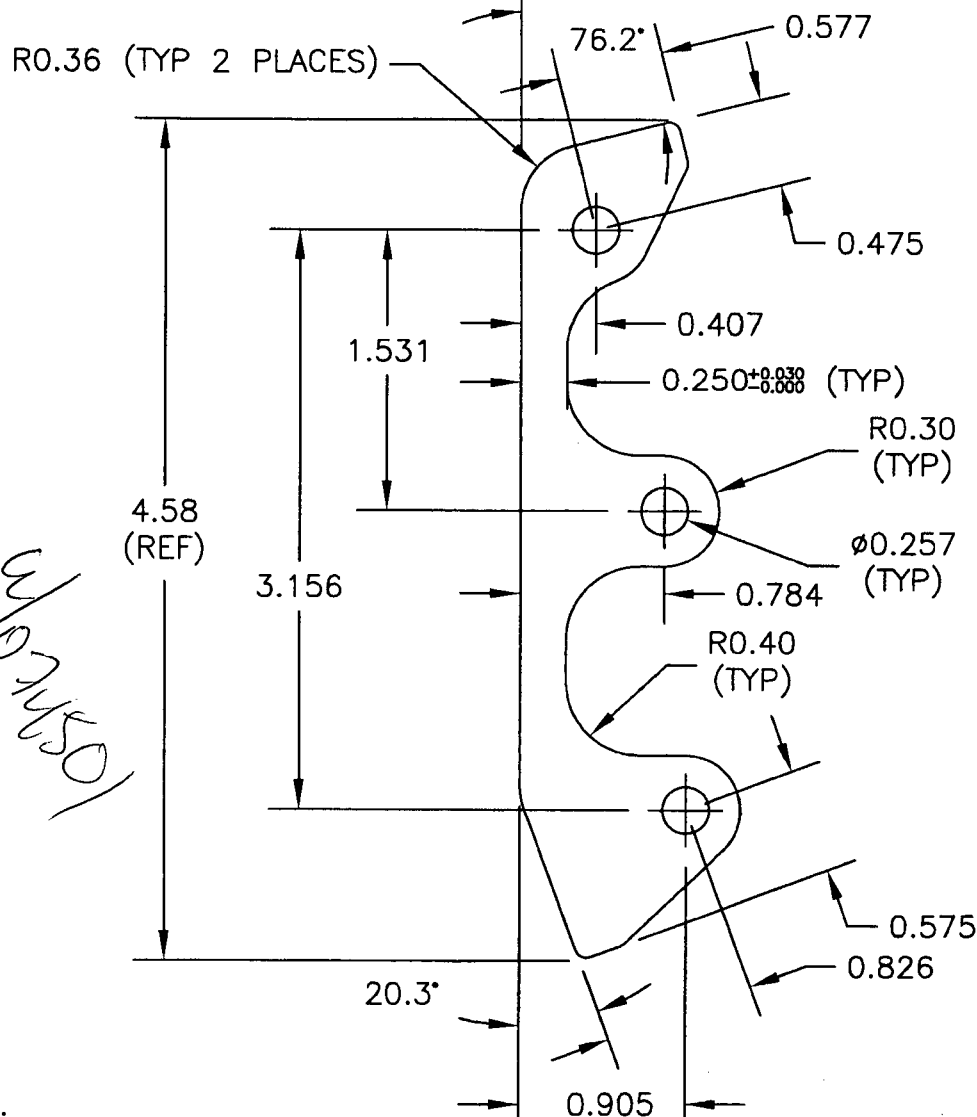
[illegible]

Measured by: B	Audited by: 	Prototype Approval: N/A
Date: 11-10-4	Date: 11/10/15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	08.08.27	0.080 dimension added	KJ/DD	

DART

DESIGN 7#	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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